

# Work Order ID 126845

**\*126845\***

Page 1

November-27-14 9:13:19 AM

Item ID: D5122-1TRN

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Center Support, Upper, Turning Detail

Start Date: 28/11/2014 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 05/12/2014 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

*[Signature]* 14.11.27

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5122	A

100

0.00

**\*100\***

MORI SEIKI CNC LATHE LARGE

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FB325

6  $\phi$  **DAS 25 9-89** **DAS 40 9-89** 14/11/29

110

0.00

**\*110\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

6  $\phi$  **DAS 25 9-89**

120

0.00

**\*120\***

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

6  $\phi$  JFC 2014-11-29



# Work Order ID 126845

**\*126845\***

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November-27-14 9:13:19 AM

Item ID: D5122-1TRN Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Center Support, Upper, Turning Detail  
Start Date: 28/11/2014 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 05/12/2014 Req'd Qty: 6.00 **\*6\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Packaging					6	0		JTC 2014-11-29
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban								
	Location: <b>mh100</b>								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

14/12/2 JF

AP4-1208



# Picklist Print

November-27-14 9:13:18 AM

Page 1

Work Order ID: 126845

**\*126845\***

Parent Item: D5122-1TRN

**\*D5122-1TRN\***

Parent Item Name: Center Support, Upper, Turning Detail

Start Date: 28/11/2014

Required Date: 05/12/2014

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV. A NEW ISSUE JFS 14/07/09 VERIFIED BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-011		Manufactured	No			100	Each	12.0000	1	6			

**\*D6104-011\***

17-4 SS Roundbar 6.50"OD

\*\*

SL 14-11-28

Location

Loc Qty

Loc Code

MAT043

12

106719

1

110138

3

120229

8

#6



[illegible]

H:\FORMS\Quality Assurance\approved QA\FAI revE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

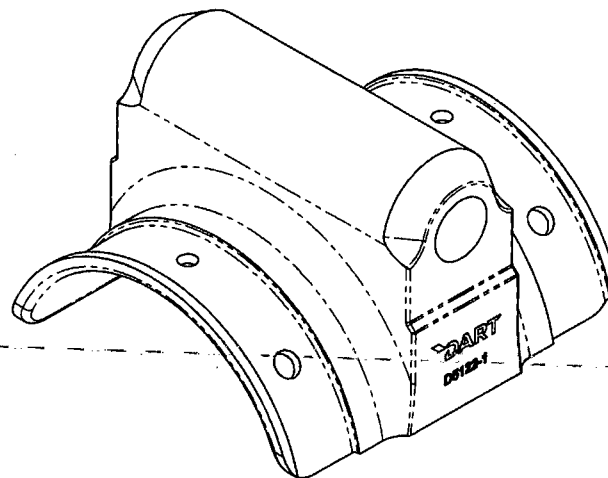
Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other





**D5122-1 CENTER SUPPORT**

**RELEASED**  
2014-08-25

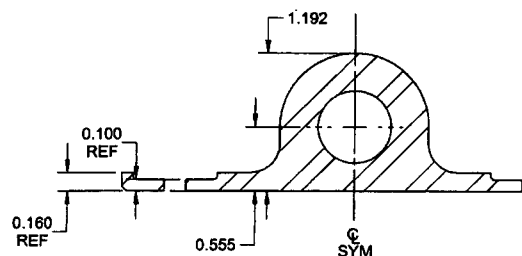
**NOTES:**

- 1) MATERIAL: MAKE FROM D5122-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5122-1" IN AREA SHOWN  
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,  
IDENTIFY WITH DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: 2.13 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5122-1-REVA.SLDPRT"

APPROVED	A	NEW ISSUE		AP	14.06.02
	REV.	DESCRIPTION		BY	DATE
	DESIGN	AP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
	DRAWN	AP			
	CHECKED	CP	DRAWING NO. <b>D5122</b>		REV. A
	MFG. APPR.	JLM	TITLE <b>CENTER SUPPORT</b>		SHEET 1 OF 3
	APPROVED	MP	SCALE		NTS
	DE APPR.	DS	DATE <b>14.06.02</b>		

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**SECTION A-A**

HOLES PERPENDICULAR  
WITHIN 0.005 OVER  
ENTIRE LENGTH

R0.063  
AROUND INSIDE EDGE

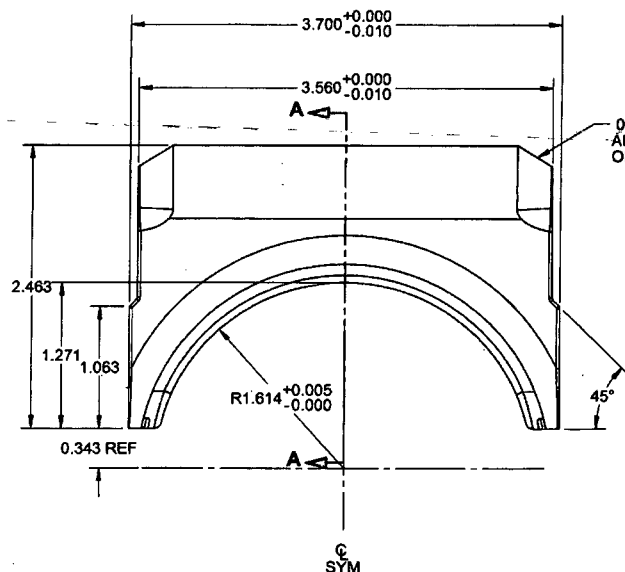
0.464 REF

OPTIONAL  $\phi 0.261$  REF  
TOOLING HOLE,  
LOCATED AT 45° TO VERTICAL  
4 PL

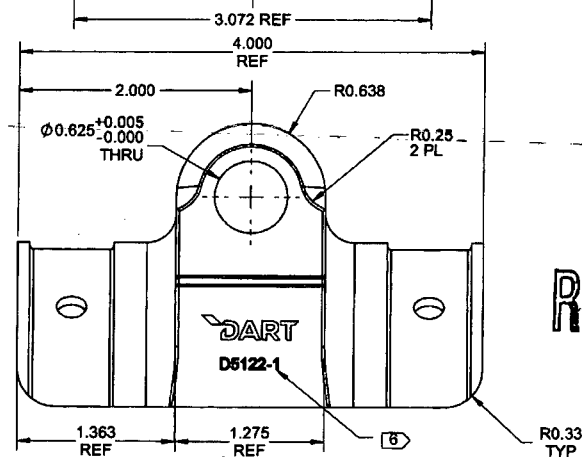
OPTIONAL  $\phi 0.189$  REF  
TOOLING HOLE,  
2 PL

HOLES PERPENDICULAR  
WITHIN 0.005 OVER  
ENTIRE LENGTH

0.18 X 58° CMF  
ALONG TOP EDGE  
OF R0.638 (REF) EDGE



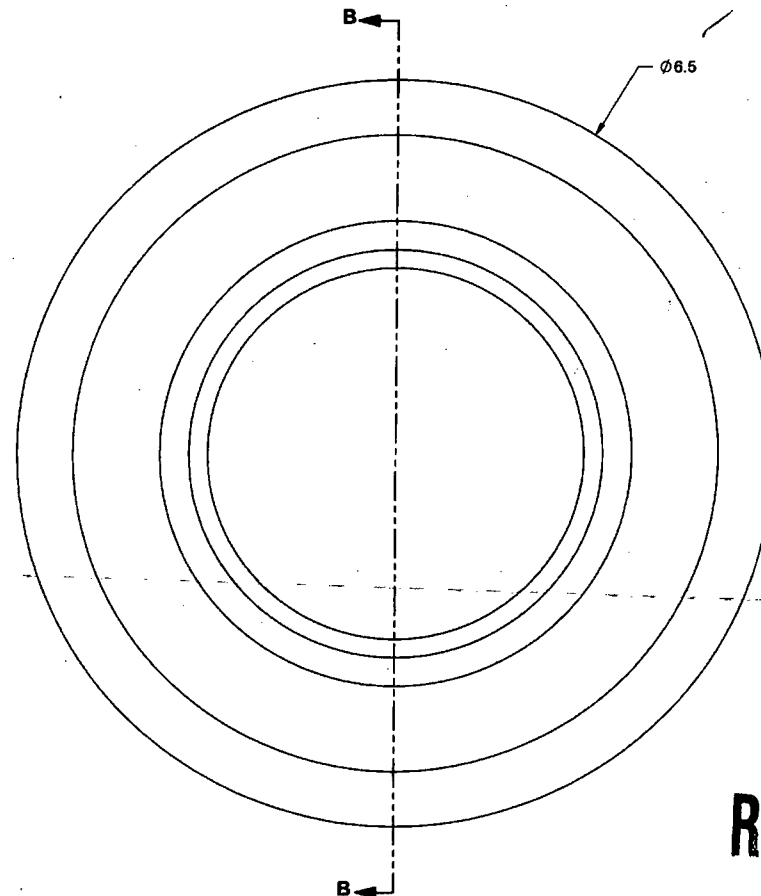
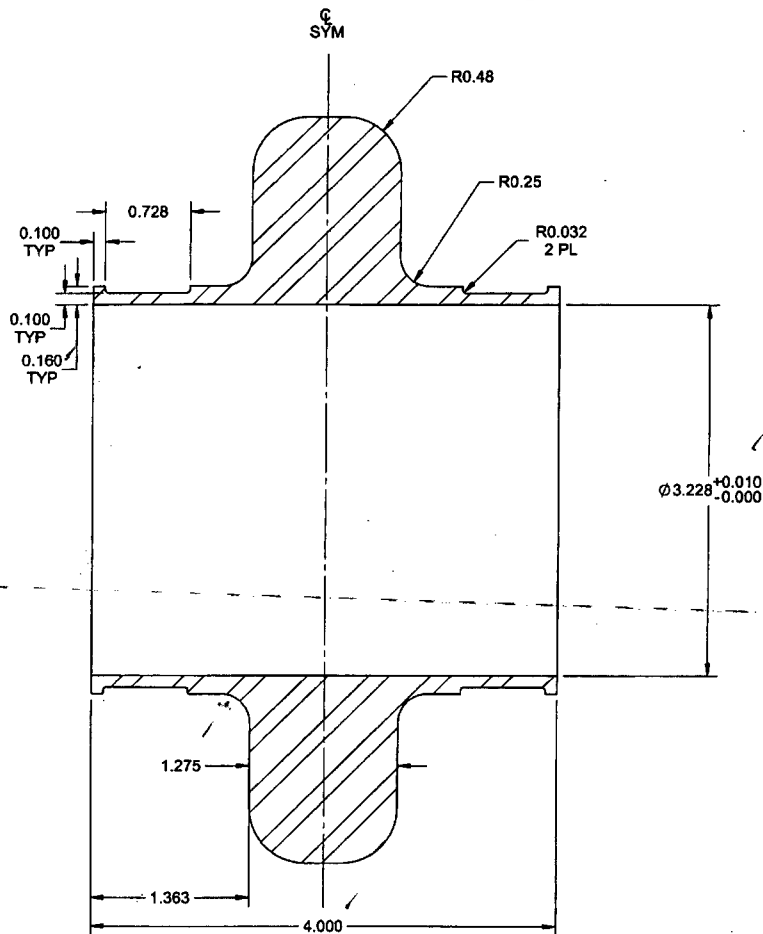
**D5122-1 CENTER SUPPORT**



**RELEASED**  
2014-08-25

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	DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	CP	DRAWING NO.	REV. A
	MFG. APPR.	JLM	<b>D5122</b>	SHEET 2 OF 3
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	<b>CENTER SUPPORT</b>	NTS
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**RELEASED**  
2014-08-25

**D5122-1TRN CENTER SUPPORT**

**NOTES:**

- 1) MATERIAL: 17-4PH/S17400/TYPE 630 ROUND BAR PER AMS 5643 / ASTM A564, REF DART SPEC. M17-4-R H900 OR H925 CONDITION, MIN UTS = 170 KSI (38 HRc)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 11.25 lbs

APPROVED	DESIGN	AP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AP		
	CHECKED	CP	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D5122	SHEET 3 OF 3
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	<b>CENTER SUPPORT</b>	NTS
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